

Date: Wednesday, 12/11/2008 1:40:59 PM
User: Julie Dawson

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : BLUE
Job Number : 43382	
Estimate Number : 10804	
P.O. Number :	Part Number : D26511
This Issue : 12/11/2008 S.O. No. :	Drawing Number : D2651-1
Prsht Rev. : NC	Project Number :
First Issue : / / Type : MACHINED PARTS	Drawing Revision :
Previous Run : 34882	Material :
Written By :	Due Date : 10/12/2008 Qty: 220 Um: Each
Checked & Approved By : <u>JLD 08.11.12</u>	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6R0500	6061-T6 Round Bar .500"
<p>Comment: Qty.: 0.0421 f(s)/Unit Total : 9.2631 f(s) Material: 6061-T6 (QQ-A-225/8) 0.500" Dia (M6061T6R0500) Batch: <u>M109396</u> <u>DJP 08/11/14</u></p>		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
<p>Comment: HAAS CNC VERTICAL MACHINING #1 1- Turn as per Folio FA219 and Dwg D2651 2- Deburr <u>DJP 08/11/14</u> 221 222</p>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>DJP 08/11/14</u> 221 222</p>		
4.0	QC8	SECOND CHECK
<p>Comment: SECOND CHECK <u>ML 08/11/14</u> 221 222</p>		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
<p>Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr ias per dwg D2651 <u>DJP 08/11/14</u> 221 222</p>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(222X)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MF 08/11/17

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: -PRIME B109992

-PAINT DELFLEET BLUE B105918

-CLEAR DELFLEET B109816

only large section necessary

MF 08 12 03

8.0

QC14

INSPECT SPRAY PAINT



08-12-04

Comment: INSPECT spray painting

(222) 222 counted.

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FIP-A

MF 08-12-04

(222X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/04 MF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

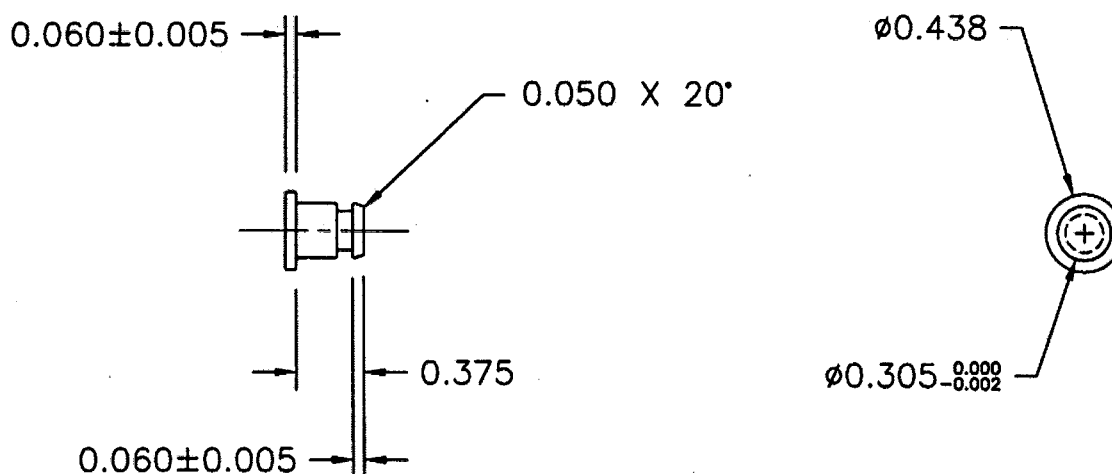


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

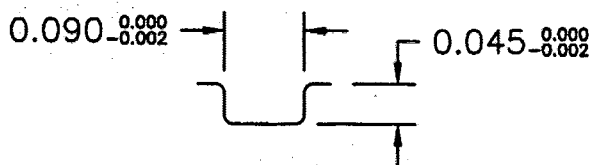
RELEASED

03.12.19

D2651-1 PLUG:



GROOVE DETAIL (SCALE 5:1)



D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16 ID, 5/16 OD, 1/16 WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43382

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